

Work Order ID 52057

September 15, 2009 1:08:46 PM



Page 1

Item ID: D2965

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cap, 105 Skidtube

Start Date: 9/15/09 Start Qty: 50.00



Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: *CZ*Date: *09/09/15* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2965

Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *10407* Cast per Dwg D2965! Material Release Note
Required*CZ 09/09/16 50*

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

09/11/13 (56)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

*27 502/1/19**counter (56) /*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52057

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Drill as per Dwg D2965 with DT8538 Deburr and Tumble

7 m, 1 09/11/30

56x

140



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

2 S 07/11/30

count

56

150



Powdercoat

Powder Coating

Powdercoat

Memo

0.00

0.00

Mask as per Dwg D2965 Powder To match Skidtube (Ref: 4.3.5.x) as per QSI
005431 START TIME: 9:00 OVEN TEMPERATURE:

FINISH TIME: 9:30

BR 09-02-01

56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52057

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Page 3

Item ID: D2965

Accept



Setup Start



Revision ID: B

Item Name: Cap, 105 Skidtube

Stop



Start Date: 9/15/09 Start Qty: 50.00



Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MO 09/12/01 150

170

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Install Inserts as per Dwg D2965

JP 09/12/01

V56

d

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 09/12/01

counters
x56

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 15, 2009 1:08:45 PM

Page 1

Work Order ID: 52057

Parent Item: D2965RevB

Parent Item Name: Cap, 105 Skidtube

Comments:

Start Date: 9/15/09

Required Date: 9/30/09

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			170	Each	877.0000	100.0000			



INSERT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

100895

100896

102018

110118

111529

111581

877

21

102

102

52

300

300

1110768

170

Each

0.0000

50.0000

D2965PRevB

Purchased

No



Cap

YAP 2 21 09/12/01

MF 09-12-02

1-56
2
112

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

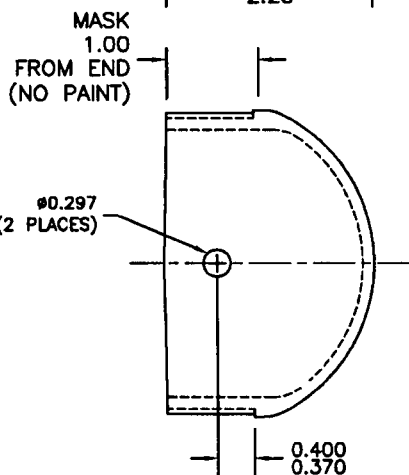
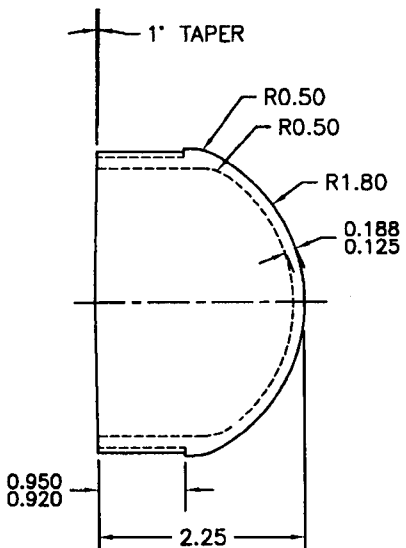
NOTE: Date & initial all entries

DART

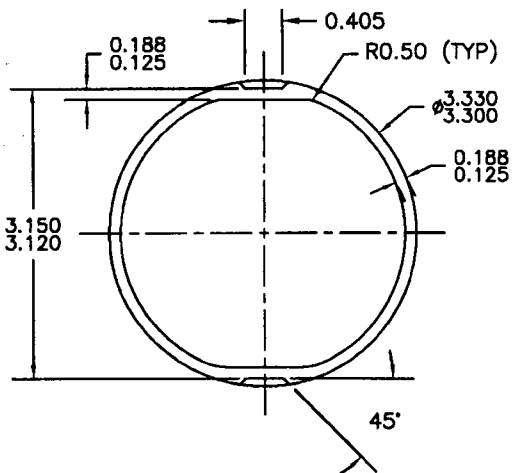
RELEASED

06.12.12

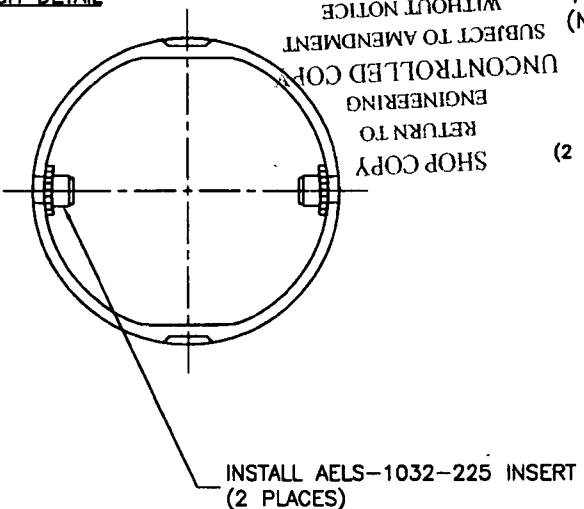
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
014	014	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D2965	SHEET 1 OF 2	
DATE		TITLE	SCALE	
06.11.01		CAP	1:2	
A	00.02.24	NEW ISSUE		
B	06.11.01	ADD -3 CAP		



D2965 CASTING DETAIL



D2965 FINISH DETAIL



NO WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

D2965 CAP

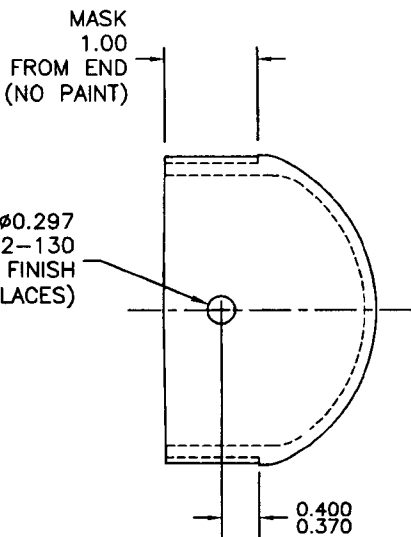
- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.11.01	TITLE	CAP	REV. B
		DRAWING NO.	D2965	SHEET 2 OF 2
		SCALE	1:2	

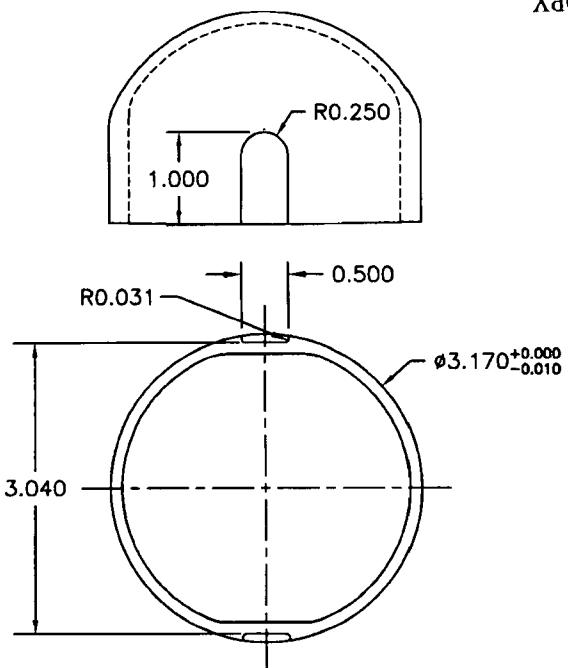
RELEASED

REV. B



D2965-3 FINISH DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58057



D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

Aluminum Foundry Ltd

2225 Chemin St. Francois
Dorval, Québec H9P 1K3
Tel: (514) 683-9777
Fax: (514) 683-0375

email: info@foundryafpw.com

Packing Slip

Packing Slip No.:

33191

Shipped Date:

Nov 10, 2009

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 10407	
Shipped By:	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z200080	Each	D2965 CAP S 02/11/19 Received by: Date:	56
Comment:			

DART
aerospaceDart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10407

Purchase Order Date 9/16/09

PO Print Date 9/16/09

Page Number 1 of 1

Order From :

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CAREVISED
\$\$\$

Contact Name

Vendor Phone 514 683 9777

Vendor Fax 514 683 0375

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

CAD

FOB

FAXED

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2965P B	Cap	9/30/09 Yes	50.00 Each	FedEx Economy	\$18.8000	\$940.00

Special Inst: AS PER DWG D2965 REV. B
B52057
CAST ALUMINUM ALLOY A356.2
(F)

PO Total: \$940.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERYMATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 2

Change Date: 9/16/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

70 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

714-718 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Ath.
Chantal
2nd time

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **10/11/2009** Slip No. **33191**

Hawksbury, ON, K6A 1K7

Votre No. Commande **10407**
Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'autorisation Incoming Release note
56	D 2965 CAP <i>Siluh?</i>	Z200080	A356.2	ingot#852723

**Analyse
Analysis (as in Ingot)**

(Si)	6.80%	(Al)	balance
(Fe)	0.08%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.38%		
(Zn)	<0.01%		
(Ti)	0.15%		

Donne
Yield :

Résistance à la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Par/Per :

Coc-100